# **Work Order ID 69571**

Quality Control

Thursday, May 12, 2011 11:18:44 AM

Page 1

Item ID:	D3199-3				Accept				<b>  </b>       :	Setup Sta	rt	
Revision ID:										S4.		
Item Name:	Bracket, Fwd L	H								Sto	)P	
Start Date:	5/12/2011	Start Qty: 4.00				Cust Item	ID:					
Required Date:	5/16/2011	<b>Req'd Qty:</b> 4.00				Customer:						
Reference:												
Approvals:	Process Plan	n: /	Date:		Tooling:	D	ate:		I	Run Sta		
	QC:		Date:	<b>_</b>	<b>SPC (Y/N):</b>	D	ate:			Sto	'P	
Sequence ID/ Work Center II		Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr				<del></del>						
D3199	D									,		
100		1,			0.00							
		FLOW WATER JET			•				<i>5</i> 0	÷ .5		
Waterjet		Memo			0.00				_B(!-	-> <del></del> (-&		
FLOW CNC Waterje	et	Cut as per	r Dwg D3199								17	
364.040		Dwg Rev: Prog Rev:										)
		Deburr if	required									
110    <b>                      </b>		QC2- Inspect parts off	f machine FAI/FA	IB	0.00	, ,			~			
QC		Memo			0.00				16	71-2-13		

Dart Ae	rospace I	Ltd							* ;
W/O:				WORK ORDER	CHANGES				
DATE	STEP		PR	OCEDURE CHANGE	В	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
		•					-		
				,					
Part No	):		PAR #:	Fault Category:	NCR:	Yes No DG	A:	Date: _	
	Res	solution:		Disposition:	QA: N	C Closed:		Date: _	
NCR:			·	WORK ORDER NON-CON	FORMANCE (I	NCR)	***************************************		
				OAdire Anti-		T	***	T	T

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
	-											
								,				
							1					
		,										

#### Work Order ID 69571

Thursday, May 12, 2011 11:18:44 AM

Item	ID:
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D3199-3

Accept



Setup Start



Run



**Revision ID:** 

Item Name:

Bracket, Fwd LH

Start Date:

Required Date: 5/16/2011

5/12/2011

Start Qty: 4.00 **Req'd Qty:** 4.00

**Cust Item ID: Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Date:

Start

Stop



Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Stop

Sequence ID/ Work Center ID

120

Quality Control

**Operation** Description

QC8- Inspect parts - second check

Memo

Memo

d'uns13

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

130

Brake NC

Bend as per dwg

Small Fab

0.00

0.00

SB 1105/13

Brake NC

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00 8 lucs/13

W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No	*	PAR #:	Fault Categ	gory:	_ NCR: `	es 1	lo <b>DQ</b> /	A:	Date:					
•		esolution:						•						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	ICR)	) -							
DATE	STEP	Description of NC			ion B		Verific	ation	Approval Chief Eng	Approval				
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C		QC Inspector				
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		A. A.				•								
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				*										

Page 3

Insp.

Stamp

Thursday, May 12, 2011 11:18:44 AM Item ID: D3199-3 Accept Setup Start **Revision 1D:** Stop Bracket, Fwd LH Item Name: Start Qty: 4.00 5/12/2011 **Start Date: Cust Item ID: Required Date: 5/16/2011** Req'd Qty: 4.00 **Customer:** Reference: Run Start **Tooling:** Process Plan: Date: Date: Approvals: Stop Date: \_\_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Tool # Plan Reject Operation Set Up/ Tool ID Accept Reject **Work Center ID** Description Run Hours Qty Code Qty Number Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3 0.00 Powdercoat Powder Coating QC3-Inspect Part Finish 0.00

170

Identify as per dwg & Stock Location: 2368

Packaging

Quality Control

Memo

Memo

Packaging

0.00

0.00

W/O:	-	WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	Ву	1	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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Dort No	_	DAD #-	Fault Cat		NCD. V		DOA:	Data						
Part NO					NCR: Yes No DQA: Date:									
	nes				~·····		ea:	Date; _						
NCR:			WORK ORL	DER NON-CONFORM	ANCE (N	CH)								
DATE	STEP	Description of NC	4		ion B	0	Verification		Approval					
	0,0,	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Section C	Chief Eng	QC Inspector					



Thursday, May 12, 2011 11:18:44 AM

Item ID:

D3199-3

Accept



Setup Start

Stop

Revision ID:

Bracket, Fwd LH Item Name:

Required Date: 5/16/2011

**Start Date:** 

5/12/2011

Start Qty: 4.00 Req'd Qty: 4.00

Date:

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/

Work Center ID

180

Operation Description

OC21- Final Inspection - Work Order Release

Set Up/ Run Hours

Tool ID

Tool # Plan Accept Qty · Code

Reject Qty

Run

Reject Insp. Number

Stamp

Memo

0.00

0.00

Quality Control

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·						
Part No	:	PAR #:	Fault Ca	tegory:	_ NCF	R: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Disposit	ion:	_ QA:	N/C CI	osed:	Date: _		
NCR:		1	WORK OR	DER NON-CONFORMA	ANCE	(NCR	)			
DATE	STEP	Description of NC		ion B		Verific	cation	Approval	Approval	
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		on C	Chief Eng	QC Inspector
					·					

#### **Picklist Print**

Thursday, May 12, 2011 11:18:41 AM

Work Order ID: 69571

Parent Item:

D3199-3

Parent Item Name: Bracket, Fwd LH



Start Date: 5/12/2011

Required Date: 5/16/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: RevC-prelim DD verified by:EC

11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	86.7000	0.1673	0.704421	1.5		
										Æ	11-5-17	L	

|--|

304/316 .040 Sheet

<b>Location</b>	Loc Oty	Loc Code		
MAT020	86.7			( <del>**</del>
116623	0.2		×	
117550	86.5		117 550	

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W/O:			V	ORK ORDER CHANG	ES	·····	***************************************			
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		,	·							
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR	: Yes T	lo DQ	A:	_ Date: _	
	R	esolution:	Disposit	_ QA:						
NCR:		V	VORK OR	DER NON-CONFORM	ANCE	(NCR)	)			
DATE	STEP	Description of NC		tion B		Verific	cation	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Sect	on C	Chief Eng	QC Inspector
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-										

DART AEROSPACE LTD	Work Order:	69571
Description: Bracket	Part Number:	D3199- <b>4</b> /3
Inspection Dwg: D3199 Rev: D		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

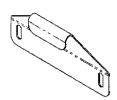
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.615	+/-0.010	-615	\		V 1362	
0.295	+/-0.010	. >98	8		V	
0.500	+/-0.010	,500	<b>X</b> =		V	
2.750	+/-0.010	3,748	ملا		ν	
4.030	+/-0.010	4.032	l.		ν	
8.030	+/-0.010	8,047	x		V	
0.990	+/-0.010	,995	8		V	
3.00	+/-0.030	3,002	8		V	
3.64	+/-0.030	3.648	8		V .	
4.02	+/-0.030	4.017	>		V	
0.040	+/-0.010	,036	۶		V	
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Measured by:	Audited by:	Preliminary Approval:
Date: 11-5-17	Date: 11/05/13	Date:

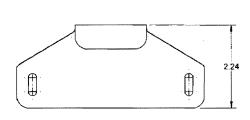
A 10.12.21 New Issue KJ	Approved	Revised by	Date Change	Rev Date	Rev
	/1	KJ 10	10.12.21 New Issue	A 10.12.2	Α
B 11.04.06 Dimensions updated per Dwg Rev D KJ	A	KJ 🔾	11.04.06 Dimensions updated per Dwg Rev D	B 11.04.0	В

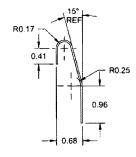
W/O:		WORK ORDER CHANGES								
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D. 1 M			- '							
Part No		PAR #:								
	R	esolution:					_	_	Date:	
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DATE	STEP	Description of NC			ection B	0: 0	Verificatio		Approval Chief Eng	Approval
DAIL	SILF	Section A	Initial Action Description Chief Eng Chief Eng		n	Sign & Date	Section	on C		QC Inspector
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NOTE: D	│ ate & initi	al all entries								

1.500 -- 1.830 R0.30 TYP Œ BEND LINES REF R0.01 R0.105 TYP 2.971 GRAIN DIRECTION 4PL 2.29 T 2.015 REF 0.575 1.00 1.090 REF 0.315 0.400 4.030 4.830



#### **D3199-1F FLAT PATTERN**





D3199-1 BRACKET MADE FROM D3199-1F

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

٥	RE-DESI TO ELIM INSTALL	GNED D3199 INATE BINDI ED. REF.: P	-3/-4/-3F PER CUSTOMER FEEDBACK NG OF DOOR ONCE BRACKETS ARE AR11-79	R FEEDBACK ACKETS ARE MB 11.03.21			
С	ACD -3/-	4 PART (SHE	ET 2-4)	HS	09.11.19		
В	2.24 WA	S 2.142; ADD	FINISH; UPDATE OWG	СВ	06.11.01		
A	NEW ISS	UE		CP	03.08,05		
REV.			DESCRIPTION	BY	DATE		
DESIGN J GY			DART AEROSPACE LTD				
DRAW	N	-	HAWKESBURY, ONTARIO, CANADA				
CHEC	(ED	#35	DRAWING NO.		REV. D		
MFG.	APPR.	W	□D3199	SHEET 1 OF 4			
APPROVED 100		ND.	TITLE	SCALE			
DE APPR.			BRACKET		NTS		
DATE	11.0	3.21	COPYRIGHT © 2003 BY DART APROSPACE LTD  THIS DOCUMENT IS TRIVIATE AND CHICKLESS OF DART APPROACH THE STREET OF THE				

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NOTE ORIENTATION OF HOLES WHEN BENDING - R0.17 2.24 2.03 REF 2.75\_ REF -0.49 REF D3199-3 BRACKET MADE FROM D3199-3F DESIGN DRAWN CHECKED DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D3199 SHE REV. D SHEET 2 OF 4 MFG. APPR. APPROVED DE APPR. TITLE SCALE TITLE
BRACKET

COPYRIGHT 6: 2005 BY DART A EROSPACE LTD

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1150 DOQUEGE OF WINNING HOUSE A EROSPACE LTD

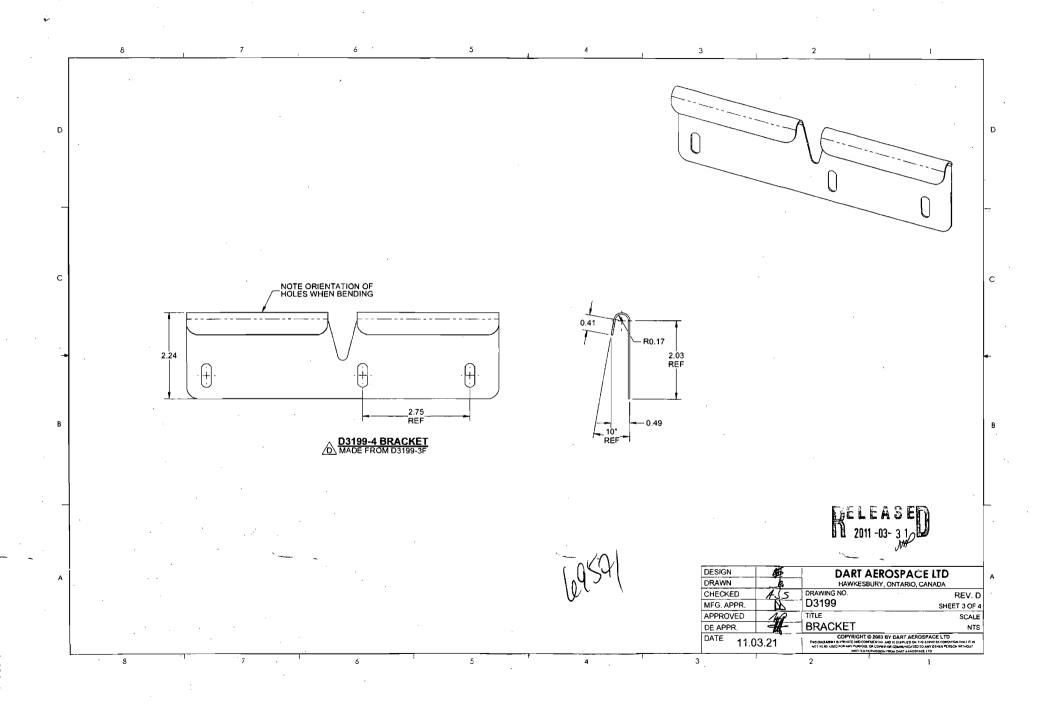
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D REF BEND LINE REF GRAIN DIRECTION 3.00 2.31 2.07 REF TYP 0.615 TYP 0.990 \_R0.125 TYP 0.295 7.50 R0.13 R0.30 0.500 8 PL 8.030 **D3199-3F FLAT PATTERN** NOTES:
1) MATÉRIAL: AISI 304/316 SS SHEET, 0 040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.26 lbs REV. D D3199 W MFG. APPR. SHEET 4 OF 4 TITLE APPROVED SCALE **BRACKET** DE APPR. NTS COPYRIGHT © 2003 BY DART AEROSPACE LTD
THIS DOCUMENT IN THE FORTH AND CONTRIBUTION AND IN MARKET TO THE FORTH COMMITTEE TO THE FORTH COMM DATE 11.03.21

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